



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636
Job Sheet 2005



Part No: D350-636-021

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 10/18/19

Description: SIOP

Type: Stock

Note: D2750-051 REV.H / IIN-D350-636 REV.K IPP REV:A 18.11.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Skidtubes - 1	1 pcs	10/18/19		0.00	4.55	Skidtubes - 1		TF BE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Skidtubes - 2 - B4B	1 pcs	10/18/19		0.00	4.55	Skidtubes - 1 - B4B		BE
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		SEP 23 2019
							QC 10 - 18		
							QC 10 - 24	DAS	
							QC 10 - 43	24	
							QC 10 - 50	9-89	
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		

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					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	SEP 23 2019 DAS 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00	0.93	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 24 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	10/18/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	BE
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	

				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
160 Skidtubes - 3 - B4B	1	10/18/19	0.00 4.55	Skidtubes - 1 - B4B	
	pcs		1.29 TF	Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1	10/18/19	0.00 0.00	QC 10 - 10	
	pcs			QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1	10/18/19	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	

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				QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.93	Handfinish - 2 - 1 - B4B	★ OCT 11 2019
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.91	Spray Paint - 1 - B4B	• RQ 19-10-13
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
205 Outsource - 10 - Consignment	1 pcs	10/18/19		ATE003-VC 5	
210 QC 14	1 pcs	10/18/19	0.00 0.00	QC 14 - 15	M 19-10-15
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00 0.93	Handfinish - 4 - 1 - B4B	M 19-10-15
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 16 2019 DAS 40
					QC 5 - 61	9-89
					QC 5 - 81	
250	Packaging 1-1 - Pick Kit - B4B	1	10/18/19	0.00 0.00	Packaging 1 - 1 - B4B	
	pcs				Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	DAS 28
					Packaging 1 - 6 - B4B	9-89
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260	QC 4	1	10/18/19	0.00 0.00	QC 4 - 28	
	pcs				QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	DAS 78
					QC 4 - 74	NOV 11 2019
						9-89
</						

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				QC 4 - 75	
270	Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
275	DC - 1 - B4B	1 pcs	10/18/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
280	QC 21 - FG	1 pcs	10/18/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

DAS

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9-89

NOV 11 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg

Descriptions: D2750-5 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-5 details). Drill using drill Jig DT8150. 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail BF to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: ~~139011~~ 8-Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - 1-Open up holes using hole saw of Detail BG and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4-Chamfer holes of Detail BG, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-

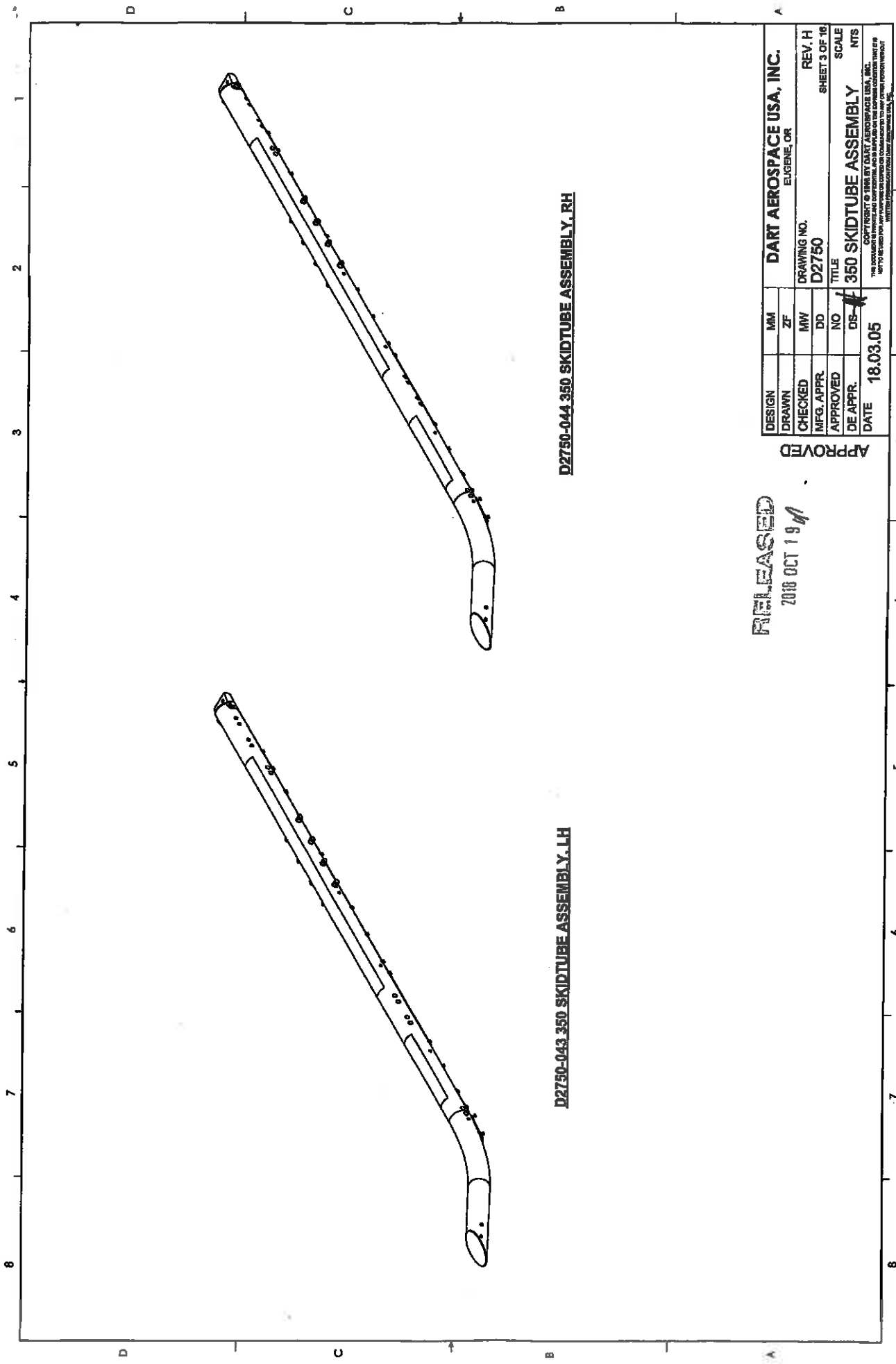
- Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required, 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5200625 exp. date: 07/25/2020 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 15) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section CS-CS (total of 4 places per side) as per dwg D2750 12-Debur holes, ensure tube is free of all scratches before sending to paint.
- 170 - (QC10- Inspect visual per QSI004- ground welds)
- 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
- 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
- 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125
- 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
- 230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5200625 EXP DATE: 20-2-27 5- Coat all exposed fasteners with "LPS Procyon" batch: 5132641
- 240 - (QC5- Inspect part completeness to step on W/O)
- 250 - Pick Kit)
- 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
- 270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-021 Location : FG108
- 275 - record fwd angle: _____ Photocopy blue file and type labels per PPP D350-636-021 CHG 001
- 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	90-Skidtubes - 1	02418
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 2 - B4B	5197857
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 3 - B4B	5192776
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 3 - B4B	5204179
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5194332
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216219
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5217714
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5216233
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5217982
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5206358
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5184950
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5207777
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5211422
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5208341
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5210540
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5216287-7
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	521506-1
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5218121
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-3
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192155
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186096-1
MS21043-3	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	520191
NAS1149C0363R	Washer (AN960C10)	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	5049569
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5135100
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	0184404
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197663
NAS1149C0833L	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5015006
				5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-LH	1	4	0
110-Skidtubes - 2 - B4B	D2744	1	38	0
160-Skidtubes - 3 - B4B	D2739	1	7	0
	D2743	8	143	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	854	0
	AN3C34A	1	33	0
	AN3C5A	34	689	0
	AN3C6A	4	95	0
	AN6C44A	4	60	0
	AN8C35A	1	13	0
	D2745	8	104	0
	D3488-3	1	18	0
	D3537-1	3	152	0
	D3631-1	8	256	0
	D3791-1	1	22	0
	D3793-1	1	30	0
	D3793-3	1	18	0
	D3793-5	1	27	0
	MS21043-3	1	665	0
	MS21043-6	4	74	0
	MS21083C8	1	45	0
	NAS1149C0332R	38	3,072	0
	NAS1149C0363R	2	549	0
	NAS1149C0832R	1	269	0
	NAS1515H3L	4	43	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	81	0
	D2741	1	65	0
	MS21083C8	2	45	0
	NAS1149D0863J	2	349	0
Part Specifications				
Specifications could not be found.				

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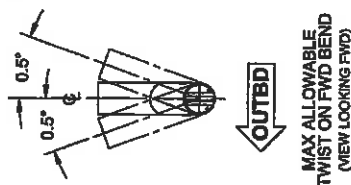


RELEASED
2018 OCT 19

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	MM	EUGENE, OR	
CHECKED	ZF	REV. H	
MFG. APPR.	MW	DRAWING NO.	SHEET 3 OF 18
APPROVED	DD	D2750	
DE APPR.	NO	TITLE	350 SKIDTUBE ASSEMBLY
DATE	DB	SCALE	NTS
18.03.05			

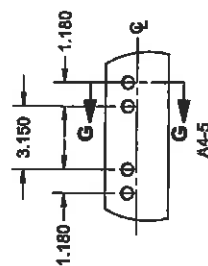
APPROVED

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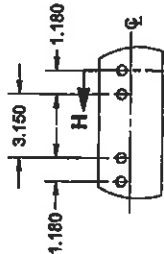


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

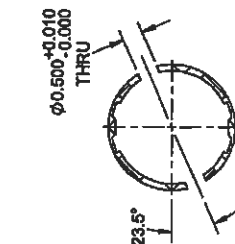
DETAIL A
SCALE 2X



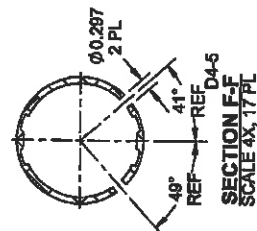
D5-5
DETAIL C
SCALE 2X



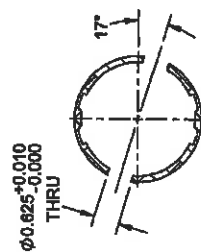
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DETAIL D
SCALE 2X



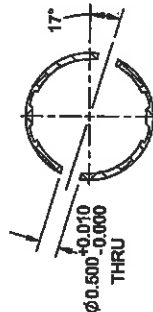
D5-5
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
SCALE 4X, 4 PL



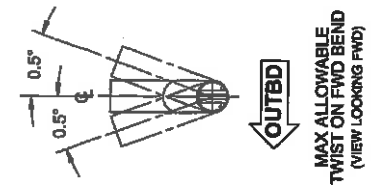
B2-5
SECTION H-H
SCALE 4X, 4PL

2010 OCT 19

DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	DRAWING NO. D2750	REV. H SHEET 6 OF 10
DRAWN	ZF			
CHECKED	MW			
MFG. APPR.	DD			
APPROVED	NO			
DATE	18.03.05	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS	CONFIDENTIALITY STATEMENT: THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC. UNLESS INDICATED OTHERWISE, IT IS NOT TO BE CLASSIFIED OR DOWNGRADED TO ANY OTHER PROTECTION CATEGORY.

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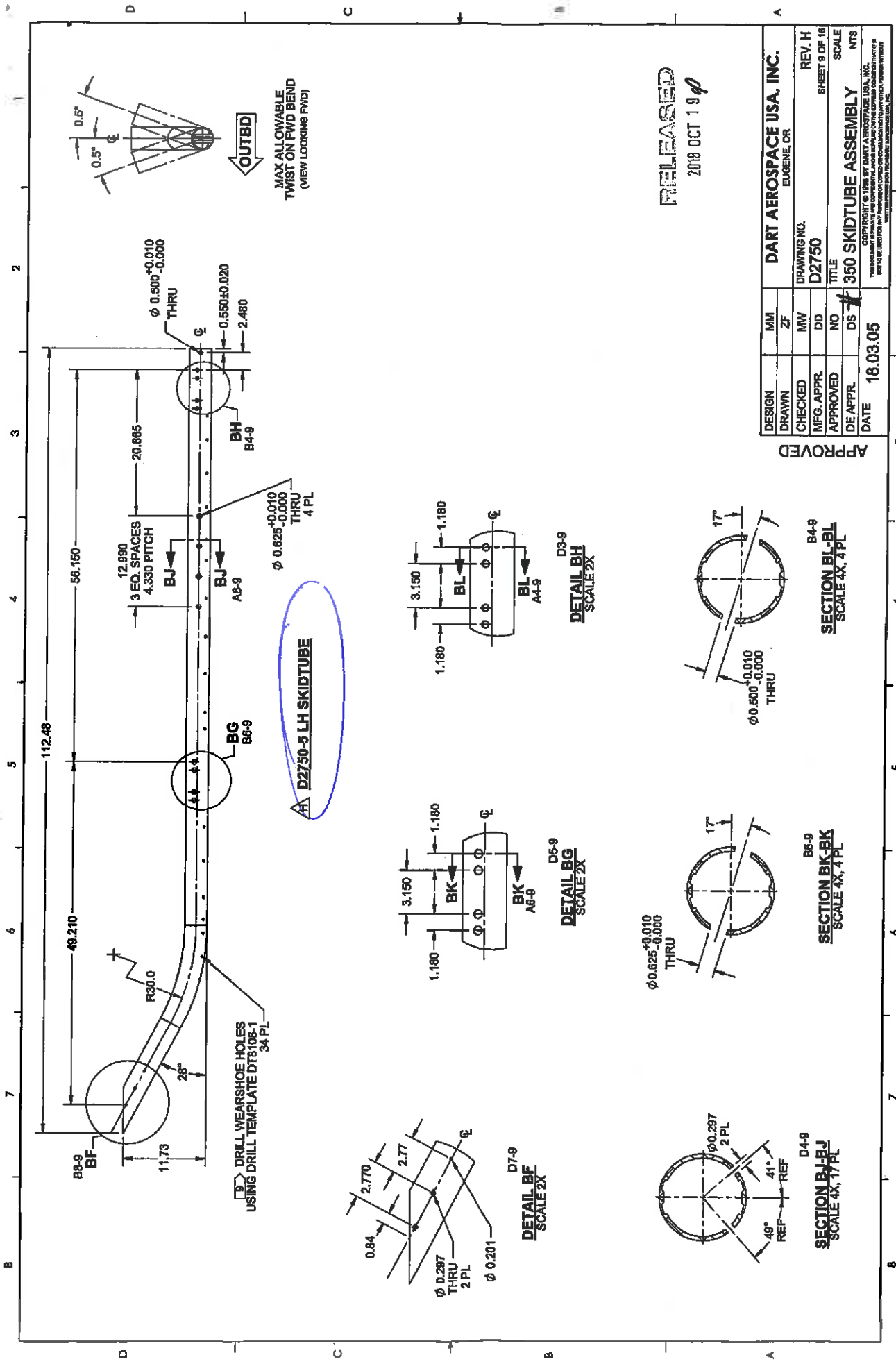
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 7 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1991 BY DART AEROSPACE USA, INC.	

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CHECKED	MM	DRAWING NO.	REV H
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUPE ASSEMBLY	NTS
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NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>										Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																				
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																				
Mislabeled	Fit/Function	Off-set/Set-up																																					
		Other/Details:																																					

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D3741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149C0832R	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149C0363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

**** PART OF D2750-051 OR D2750-052 ASSEMBLY

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Revision: K

Date: 18.04.04



RELEASED
18.10.23

JRG

PPP

Part Number	D350-636-021	Box Part Number	MBX104	Dimension	L x W x H 118.5 X 12 X 6
Description	Skidtube, LH	Other Packaging	MF6812		MF1612
		Logo Decals	D2728-1		

Packaging Instructions and Decal Placement

D350-636-021

Apply label D2729-4 & D2728-1 as per drawing below.

Wrap skidtube in plastic. Wrap hardware kit and paperwork in foam and put kit in bore of foam MF6812 (at forward end of skidtube). Glue 2 pieces of MF1612 foam, one at each end of box. Put 3 pieces of MF6812 in bottom of box. Place skidtube in box and place 3 MF6812 to correspond with bottom MF6812. Apply glue on top pieces of foam and close box. Apply Dart tape and strap. Apply D2729-3 label as per instructions in QSI 014.



D2729-4

D2729-3

DART AEROSPACE			
US #S735484 / CA #2222184 / EURO #0828655			
P/N	D350-636-021	CHG	CHG001
DESC	Skidtube, LH	STC	SH99-7
LOT	SXXXXXX	STC	SR00646SE
MODEL	AS350/355	STC	
TE APPROVED: 18/10/23			

DART AEROSPACE		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200
SKIDTUBE, LH		
P/N: D350-636-021		CHG001
S/N: SXXXXXX		

Revision: Draft
Date: 18.10.23

PAGE 1 OF 1

Description: SKIDTUBE INSTALLATION LH/RH, STD

H:\Forms\Engineer\Approved Eng Online\CHGREC revB